



Dart Aerospace Ltd.
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K6A 1K7
Canada

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D3913-041
Job Sheet 213637



Part No: D3913-041

Job Qty: 1 pcs

Part Name: Long Basket Base Assembly, 350



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/30/20

Job Tracking No:

Due Date: 10/29/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG D4020 REV A SHEET 4, D3913 REV D SHEETS 1,2,3,4,5 IPP Rev:A new issue DD 10.03.19 verified by:EC IPP Rev:B chg qty's DD 10.04.12 verified by:EC IPP REV:C 12.07.24 AS PER DWG REV:B DD VERF:EC IPP REV:D 13.08.21 DWG REV:C / ECN 13-624 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Large Fab - Basket - 1	1 pcs	10/28/20	10/28/20	0.00	19.61	Large Fab - 1		OCT 22 2020
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3	DAS	
							Large Fab - 4	24	
							Large Fab - 5	9-89	
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
							Large Fab - 12		
110	QC 9	1 pcs	10/28/20	10/28/20	0.00	0.00	QC 9 - 10		OCT 10 2020
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
120	QC 5	1 pcs	10/28/20	10/28/20	0.00	0.00	QC 5 - 10		
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		



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Container No: S308069



Part: D3913-041

Job No: 213637

Serial No/Batch: S308069

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 10/22/20

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					QC 5 - 58		
					QC 5 - 68		
					QC 5 - 9		
					QC 5 - 50	EL 10-26-20	
					QC 5 - 30		
					QC 5 - 40		
					QC 5 - 61		
					QC 5 - 81		
					QC 5 - 82		
125	Handfinish - 2-1 Pressure-B4B	1 pcs	10/28/20	0.00 0.29	Handfinish - 2 - 1 - B4B	20-10-27.	DAS 34 9-89
					Handfinish - 2 - 2 - B4B		
					Handfinish - 2 - 3 - B4B		
					Handfinish - 2 - 4 - B4B		
130	Powdercoat - 2 White Gl(S)-B4B	1 pcs	10/28/20	0.00 0.93	Powdercoat - 1 - B4B		DAS 34 9-89
					Powdercoat - 2 - B4B		
					Powdercoat - 3 - B4B	20-10-27.	
					Powdercoat - 4 - B4B		
					Powdercoat - 5 - B4B		
					Powdercoat - 6 - B4B		
					Powdercoat - 7 - B4B		
					Powdercoat - 8 - B4B		
					Powdercoat - 9 - B4B		
					Powdercoat - 10 - B4B		
140	QC 3	1 pcs	10/28/20	0.00 0.00	QC 3 - 10		DAS 15 9-89
					QC 3 - 13		
					QC 3 - 15	EL 20-10-28	
					QC 3 - 17		
					QC 3 - 18		
					QC 3 - 2		
					QC 3 - 28		
					QC 3 - 3		
					QC 3 - 30		
					QC 3 - 34		
					QC 3 - 36		
					QC 3 - 41		
					QC 3 - 51		
					QC 3 - 58		
					QC 3 - 59		
					QC 3 - 68		
					QC 3 - 9		
					QC 3 - 40		
					QC 3 - 19		
					QC 3 - 43		
					QC 3 - 24		
					QC 3 - 61		
					QC 3 - 81		
					QC 3 - 82		
					QC 3 - 87		
					QC 3 - 47		
150	Handfinish - 4-1-Assembly-B4B	1 pcs	10/29/20	0.00 0.50	Handfinish - 4 - 1 - B4B	EL 20-10-28	
					Handfinish - 4 - 10 - B4B		
					Handfinish - 4 - 11 - B4B		
					Handfinish - 4 - 12 -		

				B4B	
				Handfinish - 4 - 13 - B4B	
				Handfinish - 4 - 14 - B4B	
				Handfinish - 4 - 15 - B4B	
				Handfinish - 4 - 2 - B4B	
				Handfinish - 4 - 3 - B4B	
				Handfinish - 4 - 4 - B4B	
				Handfinish - 4 - 5 - B4B	
				Handfinish - 4 - 6 - B4B	
				Handfinish - 4 - 7 - B4B	
				Handfinish - 4 - 8 - B4B	
				Handfinish - 4 - 9 - B4B	
160	QC 5	1 pcs	10/29/20	0.00 0.00	QC 5 - 10
					QC 5 - 12
					QC 5 - 17
					QC 5 - 18
					QC 5 - 19
					QC 5 - 22
					QC 5 - 24
					QC 5 - 3
					QC 5 - 43
					QC 5 - 49
					QC 5 - 51
					QC 5 - 58
					QC 5 - 68
					QC 5 - 9
					QC 5 - 50
					QC 5 - 30
					QC 5 - 40
					QC 5 - 61
					QC 5 - 81
					QC 5 - 82
170	Packaging 3-1 - Stock - B4B	1 pcs	10/29/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B

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OCT 28 2020 40
9:30

					Packaging 3 - 15 - B4B	20-10-21
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
					Packaging 3 - 37 - B4B	DAS 21 9-30
180	QC 21 - SA	1	10/29/20	0.00 0.00	QC 21 - SA - 21	OCT 28 2020
	pcs				QC 21 - SA - 70	
					QC 21 - SA - 9	
					QC 21 - SA - 77	
					QC 21 - SA - 28	

Part Op 100 - Weld per dwg A/R S.S. rod Batch: _____ 1- assemble ribs , weld as per dwg D3913 using DT9610A ***inspect Descriptions: before welding mesh*** 2-Cut D4020-1 base mesh and tack weld all mesh on basket as per dwg D3913 and trim mesh to fit if necessary and trim to clear fasteners holes on the ends 3- weld hinge (3) and Mounting brackets as per dwg D3913 ***take lid to locate hinge and bracket*** 4- Weld D4672-1 blanking plates as per dwg

110 - QC9- Inspect visual per QSI004- Fusion Welds
 120 - QC5- Inspect part completeness to step on W/O
 125 - Pressure Wash per QSI005 4.3/ Clean and remove all markings
 130 - White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel) 1- Plug holes and mask only interior of hinge (3) prior to powder coat
 140 - QC3- Inspect Part Finish
 150 - Assemble as per dwg - Pick Kit
 160 - QC5- Inspect part completeness to step on W/O
 170 - Identify as per dwg & Stock Location: _____
 180 - QC21- Final Inspection - Work Order Release

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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D2581	Mounting Bracket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5297542
D3913-1	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5300929
D3913-15	Wide Handle Plate	1 pcs (1 ea)	100-Large Fab - Basket - 1	5267768
D3913-3	Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5307660
D3913-7	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5306796
D3913-9	Hinge Rib	1 pcs (1 ea)	100-Large Fab - Basket - 1	5266454
D3916-041	Rib Assembly	2 pcs (2 ea)	100-Large Fab - Basket - 1	5304848
D3916-5	Light Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	5304954
D4016-1	Hinge Half, Base	3 pcs (3 ea)	100-Large Fab - Basket - 1	5257681
D4017-7	Rib	3 pcs (3 ea)	100-Large Fab - Basket - 1	5248314
D4017-9	Rib	2 pcs (2 ea)	100-Large Fab - Basket - 1	5302525
D4020-11	End Mesh, Basket	2 pcs (2 ea)	100-Large Fab - Basket - 1	5305756
D4021-1	Handle Plate	3 pcs (3 ea)	100-Large Fab - Basket - 1	5301533
D4034-041	Aft Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	5302679
D4034-043	Fwd Upper Rib Assembly	1 pcs (1 ea)	100-Large Fab - Basket - 1	5302829
D4672-1	Blanking Plate	2 pcs (2 ea)	100-Large Fab - Basket - 1	5209507
M304EX0.75-16F	Expanded Metal Flat SS	32 sf (32 ea)	100-Large Fab - Basket - 1	5256752
AN3-10A	BOLT	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	5253416-1
D2931	Bumper	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	586435
MS20600-AD4W3	Cherry Rivet	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5255355
MS21042L3	Nut	6 Ea (6 ea)	150-Handfinish - 4-1-Assembly-B4B	5304831
NAS1149F0332P	Washer (AN960-10L)	12 Ea (12 ea)	150-Handfinish - 4-1-Assembly-B4B	5216387
D4021-5	Blanking Plate	2 pcs (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5306403
NAS1149FN832P	Washer (AN960-8)	2 Ea (2 ea)	150-Handfinish - 4-1-Assembly-B4B	5136368

Job Allocations

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Operation	Component Part	Required	Inventory	Allocated
100-Large Fab - Basket - 1	D2581	2	20	0
	D3913-1	1	7	0
	D3913-15	1	17	0
	D3913-3	1	3	0
	D3913-7	2	6	0
	D3913-9	1	8	0
	D3916-041	2	2	0
	D3916-5	3	6	0
	D4016-1	3	21	0
	D4017-7	3	36	0
	D4017-9	2	10	0
	D4020-11	2	2	0
	D4021-1	3	19	0
	D4034-041	1	11	0
	D4034-043	1	6	0
	D4672-1	2	28	0
	M304EX0.75-16F	32	570	0
	AN3-10A	6	126	0
	D2931	2	449	0
150-Handfinish - 4-1-Assembly-B4B	D4021-5	2	2	0
	MS20600-AD4W3	2	224	0
	MS21042L3	6	1,014	0
	NAS1149F0332P	12	2,006	0
	NAS1149FN832P	2	1,328	0

Part Specifications

Specifications could not be found.

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					